May-30-13 1:49:52 PM Item (D: D3957-044 Accept \*N900040100\* Setup Start Revision ID: Item Name: Hinge Assembly. Door RH Lower \*1\* **Start Date:** 5/30/13 Start Qty: 1.00 **Cust Item ID:** Required Date: 6/06/13 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: \_\_\_MUT Date: 1305-30 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool # Plan Accept Reject Insp. **Work Center ID** Description Qty Qty Stamp **Run Hours** Code Number **Draw Nbr Revision Nbr** D3957 Α 100 Pick Kit 0.00 \*100\* Packaging 0.00 Memo Packaging 110 0.00 \*110\* Small Fab Memo 13/64/07 Small Fab 1-Install Helicoil in d3957-4 2-Install Rod end and Niut Loosely 120 QC5- Inspect part completeness to step on W/O 0.00

\*120\*

Quality Control

Memo

| DQA:                  |                |                    | Date:        |          |                      |                              |                        |                        |                     |                                       |                  |                                       |              | •      | TOAC              |  |
|-----------------------|----------------|--------------------|--------------|----------|----------------------|------------------------------|------------------------|------------------------|---------------------|---------------------------------------|------------------|---------------------------------------|--------------|--------|-------------------|--|
|                       |                |                    |              |          |                      | WORK ORDER NON-              | N-CONFORMANCE / UPDATE |                        |                     |                                       |                  |                                       |              |        |                   |  |
| QA Closed:            |                |                    | Date:        |          |                      |                              | _                      | Work Order update only |                     |                                       |                  |                                       |              |        |                   |  |
| Work Orde             | er:            |                    |              |          |                      | DISPOSITION                  |                        |                        |                     |                                       |                  |                                       |              |        |                   |  |
|                       | _              |                    |              |          |                      | Rework                       |                        |                        | Skid-tube           | Crosstube                             |                  |                                       | Water Jet    | ☐ E    | ngineering        |  |
| Part N                | No             |                    |              |          |                      | Scrap                        |                        | 1                      | Machining           | Small Fab                             | Prod. Eng. Coor. |                                       |              |        | Quality           |  |
|                       |                |                    |              |          | Use-as-is            |                              | Thermoforming Finishin |                        |                     | Rec/Store/Packaging                   |                  |                                       |              | Other  |                   |  |
| NCR No.               |                |                    |              |          | Suspected Unapproved |                              |                        | Large Fab              | Composite           |                                       |                  | Supplier                              | ╛            |        |                   |  |
| Root                  |                |                    |              |          | Descr                | ription of work order update | ı                      | nitial                 | Actio               | n                                     |                  | Sign &                                |              |        |                   |  |
| Cause                 |                | Date               | Step         | Qty      |                      | or non-conformance           | Ch                     | ief Eng                | Descript            | tion                                  |                  | Date                                  | Verification |        | QC Inspector      |  |
| Design                |                |                    |              |          |                      | -                            |                        |                        |                     |                                       |                  |                                       |              |        |                   |  |
| Doc/Data              | Щ              |                    |              |          |                      |                              |                        |                        |                     |                                       |                  |                                       |              |        |                   |  |
| Equip/Tooling         | $\square$      |                    |              |          |                      |                              |                        |                        |                     |                                       |                  |                                       |              |        |                   |  |
| Handling/Pre          | Щ              |                    |              |          |                      |                              |                        |                        |                     |                                       | Ì                |                                       |              |        |                   |  |
| Material              |                |                    |              |          |                      |                              |                        |                        |                     |                                       |                  |                                       |              | 1      |                   |  |
| Operator              | $\dashv$       |                    |              |          |                      |                              |                        |                        |                     |                                       |                  |                                       |              |        |                   |  |
| Offset/Setup          | $\dashv$       |                    |              |          |                      |                              |                        |                        |                     |                                       | •                |                                       |              |        |                   |  |
| Process               | $\dashv$       |                    |              |          |                      |                              |                        |                        |                     |                                       |                  |                                       |              |        |                   |  |
| Supplier              | _              |                    |              |          |                      |                              | İ                      |                        |                     |                                       |                  |                                       |              |        |                   |  |
| Training<br>Transport | $\dashv$       |                    |              |          |                      |                              |                        |                        |                     |                                       |                  |                                       |              | 1      |                   |  |
| Unapproved            | $\dashv$       |                    |              |          |                      |                              |                        |                        |                     |                                       |                  |                                       |              |        |                   |  |
| Опаррточец            |                |                    | L            | <u> </u> | L                    |                              | <u> </u>               | HT CAT                 | l<br>regory         |                                       |                  |                                       | L            |        |                   |  |
| Landi                 | ng G           | ear                | <del>-</del> |          |                      | General                      | TA                     | OLI CA                 | ILGORT              | · · · · · · · · · · · · · · · · · · · |                  |                                       |              |        |                   |  |
|                       |                | Bending            |              |          |                      | Bend                         |                        | Folio/P                | rogram              | Γ                                     |                  | Outside Dim                           | ensions [    | $\neg$ | essure/Forced     |  |
|                       | —              | Centre No          | ot Concer    | ntric    |                      | BOM/Route                    |                        | Grain                  | 10814111            | İ                                     |                  | Over/Under                            | <u> </u>     | _      | t-up              |  |
|                       | _              | Cracks             |              |          |                      | Broken/Damage/Defect         |                        | Hardwa                 | re                  |                                       | _                | Part Incorre                          | <u>-</u>     | _      | mperature/Cure    |  |
|                       | $\blacksquare$ | Crimp/Kir          | nk/Ripple    | /Wave    |                      | Burrs                        |                        | ł                      | ion Incomplete/Unqu | ualified                              |                  | Part Lost/Mi                          | <del>-</del> | =      | •                 |  |
|                       | _              | Cuffs              |              |          |                      | Contamination                |                        | 1                      | ions Incomplete/Unc |                                       | _                | Part Moved                            | · ·          | _      | rong Stock Pulled |  |
|                       | $\overline{}$  | Crushing           |              |          |                      | Countersink                  | _                      | i                      | ned/off center      | Ţ                                     | _                | Positioned V                          | _            | _      |                   |  |
|                       |                | Heat Trea          | it           |          |                      | Cut Too Short                | -                      | Mislabe                | •                   | ļ                                     |                  | Power Loss/                           |              | Oti    | her               |  |
|                       |                | nspection          | n Strip in   | Tube     |                      | Drawing                      |                        | Misread                | <b>i</b> ,          |                                       |                  | •                                     |              |        |                   |  |
|                       |                | Marks/Ch           | atter        |          |                      | Drill Holes                  |                        | Off-set                |                     |                                       |                  |                                       |              |        |                   |  |
|                       |                | Turning S          | equence      |          |                      | Finish                       |                        | Out of (               | Calibration         |                                       |                  |                                       |              |        |                   |  |
|                       |                | Wave/Twist in Tube |              |          |                      | Fit/Function                 |                        | Out of S               | Sequence            |                                       |                  | · · · · · · · · · · · · · · · · · · · |              |        |                   |  |

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Quality Control

Page 2

May-30-13 1:49:52 PM Item ID: D3957-044 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Hinge Assembly. Door RH Lower \*1\* Start Date: Start Qty: 1.00 5/30/13 **Cust Item ID:** Required Date: 6/06/13 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Approvals: Date: \_\_\_\_\_\_ Tooling: Date: Stop Date: \_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Reject Tool # Plan Accept Insp. **Work Center ID** Description **Run Hours** Qty Qty Number Stamp Code Identify as per dwg & Stock Location: 130 \*130\* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 \*140\*

0.00

Memo

MJ 5.7

| DQA:          |                  |               | Date:      |       |                                   |                              |          |                        |                                       |                                 |     |                  |              | A DT               |
|---------------|------------------|---------------|------------|-------|-----------------------------------|------------------------------|----------|------------------------|---------------------------------------|---------------------------------|-----|------------------|--------------|--------------------|
|               |                  |               |            |       |                                   | WORK ORDER NON-              | -CC      | ONFO                   | RMANCE / U                            | PDATE                           |     |                  |              | AEROSPACE          |
| QA Closed:    |                  |               | Date:      |       |                                   |                              |          |                        | · · · · · · · · · · · · · · · · · · · |                                 | Wo  | ork Order up     | odate only   |                    |
| Work Orde     | er:              |               |            |       |                                   | DISPOSITION                  |          |                        |                                       | AGAINST I                       | DEI | PARTMENT         |              |                    |
|               | _                |               |            |       |                                   | Rework                       |          |                        | Skid-tube Crosstube                   |                                 |     |                  | Water Jet    | Engineering        |
| Part N        | ۱o               |               |            |       |                                   | Scrap                        |          | 1                      | Machining Small Fab                   |                                 |     | Prod. Eng. Coor. |              | Quality            |
| NCR No.       |                  |               |            |       | Use-as-is<br>Suspected Unapproved | <b> </b>                     |          | Finishing<br>Composite |                                       | Rec/Store/Packaging<br>Supplier |     | Other .          |              |                    |
| Root          | pot De           |               |            |       | Desci                             | ription of work order update | l        | nitial                 | Act                                   | tion                            |     | Sign &           |              |                    |
| Cause         | }                | Date Step Qty |            |       |                                   | or non-conformance           | Ch       | ief Eng                | Desci                                 | ription                         |     | Date             | Verification | QC Inspector       |
| Design        | $\Box$           | -             |            |       |                                   |                              |          |                        |                                       |                                 |     |                  |              |                    |
| Doc/Data      | Ц                | _             |            |       |                                   |                              |          |                        | ,                                     | ····                            |     |                  |              |                    |
| Equip/Tooling |                  |               |            |       |                                   |                              |          |                        |                                       |                                 |     | į                |              |                    |
| Handling/Pre  | Ш                |               | }          |       |                                   |                              |          |                        |                                       |                                 |     |                  |              |                    |
| Material      | $\Box$           |               |            |       |                                   |                              |          |                        |                                       |                                 |     |                  |              |                    |
| Operator      | _                |               | 1          |       |                                   |                              |          |                        |                                       |                                 |     |                  |              |                    |
| Offset/Setup  | _                |               |            |       |                                   |                              |          |                        |                                       |                                 |     |                  |              |                    |
| Process       | _                |               |            |       |                                   |                              |          |                        |                                       |                                 |     |                  |              |                    |
| Supplier      | $\dashv$         |               |            |       |                                   |                              |          |                        |                                       |                                 |     |                  |              |                    |
| Training      | $\dashv$         |               |            |       |                                   |                              |          |                        |                                       |                                 |     |                  |              |                    |
| Transport     | $\blacksquare$   |               |            |       |                                   |                              |          |                        |                                       |                                 |     |                  |              |                    |
| Unapproved    |                  |               |            | i     | L                                 |                              | EAI      | UTCAT                  | TEGORY                                |                                 |     |                  |              |                    |
| Landii        | ng G             |               |            |       |                                   | General                      | FA       | JLI CA                 | IEGORT                                |                                 |     |                  |              |                    |
|               |                  | Bending       |            |       |                                   | Bend                         |          | leolio/B               | rogram .                              | ٢                               | 1   | Outside Dim      | onsions [    | Pressure/Forced    |
|               | -                | Centre No     | nt Concer  | ntric | <u> </u>                          | BOM/Route                    | $\vdash$ | Grain                  | Togram                                | •                               |     | Over/Under       | <b>—</b>     | Set-up             |
|               | —                | Cracks        | 0011001    |       |                                   | Broken/Damage/Defect         | Н        | Hardwa                 | ire                                   | ŀ                               |     | Part Incorred    | <u> </u>     | Temperature/Cure   |
|               |                  | Crimp/Kin     | nk/Ripple  | /Wave |                                   | Burrs                        | -        |                        | ion Incomplete/Ur                     | ngualified                      |     | Part Lost/Mi     | <u> </u>     | Weld               |
|               | _                | Cuffs         |            | ,     |                                   | Contamination                |          |                        | ions Incomplete/U                     | ·                               |     | Part Moved       | -            | Wrong Stock Pulled |
|               |                  | Crushing      |            |       |                                   | Countersink                  | -        |                        | ned/off center                        |                                 |     | Positioned V     | ∟<br>Vrong   |                    |
|               | $\overline{}$    | Heat Trea     | t          |       |                                   | Cut Too Short                | -        | Mislabe                |                                       | }                               | _   | Power Loss/      | _            | Other              |
|               | -                | nspection     |            | Tube  |                                   | Drawing                      |          | Misread                |                                       | L                               |     | 1                | U            | _1                 |
|               | $\overline{}$    | Marks/Ch      | ٠.         |       |                                   | Drill Holes                  |          | Off-set                |                                       |                                 |     |                  |              |                    |
|               | Turning Sequence |               |            |       |                                   | Finish                       |          | i .                    | Calibration                           |                                 | •   |                  |              |                    |
|               | ,                | Wave/Tw       | ist in Tub | oe    |                                   | Fit/Function                 |          |                        | Sequence                              |                                 | •   |                  |              |                    |

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Order ID: 102549

Parent Item:

D3957-044

\*102549\* \*D3957-044\*

Parent Item Name: Hinge Assembly, Door RH Lower

**Start Date:** 5/30/13

Required Date: 6/06/13

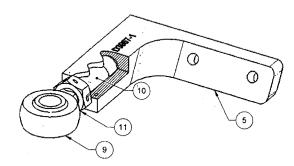
Start Qty: 1.00

Required Qty: 1.00

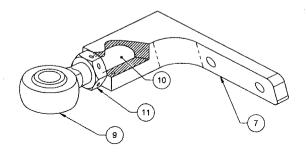
|   | Comments:                              | IPP RevA: New issu     | ie DD verified by: | :EC         |                     |                  |                 |                    |                |             |                   |               |                       |              |
|---|--|------------------------|--------------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-------------------|---------------|-----------------------|--------------|
|   | Component Item ID/<br>Item Name        | Replacement<br>Item ID | Mfg/<br>Purch      | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty      | Qty<br>Issued | Date Status<br>Issued |              |
|   | D3518-3                                |                        | Manufactured       | No          |                     |                  | 100             | Each               | 6.0000         | 1           | 1                 |               |                       |              |
|   | *D3518-3<br>Stainless Steel Ball Joint |                        |                    |             |                     |                  |                 |                    |                | **          | ·<br>···· <b></b> | F 1           | F 13-06               | -07          |
|   |  |                        |                    |             | Location            |                  | Loc             | <u>Oty</u>         | Loc Code       |             |                   |               |                       | •            |
|   | <b>*</b>                               |                        |                    |             | ST054               |                  | * *             | 6                  |                | _           |                   | _             |                       |              |
|   | MS124818                               |                        | D                  | No          |                     | 73938            | 100             | 6                  |                | _           |                   |               |                       |              |
|   |  | 40*                    | Purchased          | No          |                     |                  | 100             | Each               | 12.0000        | 1           | 1                 |               | -                     |              |
|   | *MS1248                                | 18"                    |                    |             |                     |                  |                 |                    |                | **          |                   | F             | 50166                 | 07           |
|   |  |                        |                    |             | Location            |                  | Loc             | <u>Oty</u>         | Loc Code       | -           | WIZ               | 5957          | = . /                 |              |
|   |  |                        |                    |             | ST331               |                  |                 | 12                 |                |             |                   | _             | 5 B/06/0              | 7(41)        |
|   | D3957-4                                |                        | Manufactured       | No          | £                   | 112503           | 100             | 12<br>Each         | 3.0000         |             |                   | _             | 0 10 1                |              |
| į | *D3957-4                               | i *                    | Manufactured       | 140         |                     |                  | 100             | Each               | 3.0000         | **          | l                 |               | _                     |              |
|   | Hinge, Door RH Lower                   | •                      |                    |             |                     |                  |                 |                    |                | _           |                   | <b>F</b>      | F 13-0                | 6-07         |
|   |  |                        |                    |             | Location            |                  | Loc             | <u>Qty</u>         | Loc Code       |             |                   |               |                       | •            |
|   | ,                                      |                        |                    |             | 2.0,,               | 102551           |                 | 3                  |                | _           |                   | _             |                       |              |
|   | NAS509-6                               |                        | <b>D</b> 1 1       | Nie         |                     | 95526            | 100             | 3                  |                | _           |                   | _             |                       |              |
|   |  | · <b>^</b> +           | Purchased          | No          |                     |                  | 100             | Each               | 9.0000         | 1           | 1                 |               | _                     |              |
|   | *NAS509                                | -n <sup>^</sup>        |                    |             |                     |                  |                 |                    | ,              | **          |                   | FI            | E 13-0                | <u>6.</u> 07 |
|   |  |                        |                    |             | Location            |                  | Loc             | <u>Oty</u>         | Loc Code       |             |                   |               |                       |              |
|   |  |                        |                    |             | ST276               |                  |                 | 9                  |                |             |                   | _             |                       |              |
|   |  |                        |                    |             | •                   | 113537           |                 | 9                  |                | _           |                   | _             |                       |              |
|   |  |                        |                    |             |                     |                  |                 |                    |                |             |                   |               |                       |              |

| DQA:   | Sut  | Date:        | 13/0 | 6/18  |   |                            |  |  |    |   | •   |   |  |
|--|--|--------------|------|-------|---|----------------------------|--|--|----|---|---|---|--|
|  | 11   |              | 1    | 1     | WORK ORDER NON-   | -CC                        | NFO  | RMANCE / UPDATE  |    |   |   |   |  |
| QA Closed:   | CK   | Date:        | 13   | 0/10  |   |                            |  |  | Wo | rk Order up   | odate only                                    | ]   |  |
| Work Orde  | er:  | 025          | -4 e |       | DISPOSITION   | AGAINST DEPARTMENT/PROCESS |  |  |    |   |   |   |  |
| Part No. <u>13-3212</u> NCR No. <u>13-3212</u>   |  |              |      |       | Rework Scrap Use-as-is Suspected Unapproved   |                            | Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite |  |    |   | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other   |  |
| Root   |  |              | 1    | Descr | ription of work order update  | lı                         | nitial   | Action   | T  | Sign &  |   |   |  |
| Cause  | Date   | Step         | Qty  | Ì     | or non conformance  | Chi                        | ief Eng  | Dannintian   |    | I   | Verification                                  | QC Inspector  |  |
| Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved | 13/04  | 22 110       | (    | M was | I heli coil S 124818 so sury when so Erstall ad the retap   | (n)                        | or of  | Severy destroy replace M12595/   |    | 3-06-K  | 55<br>13/06/10                                | 100010<br>Blowlo  |  |
| •  |  |              |      |       |   | FAL                        | JLT CA   | TEGO/RY  |    |   |   |   |  |
| Landir   | Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter |              |      |       | General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes |                            | Grain<br>Hardwa<br>Inspect<br>Instruct<br>Misalig<br>Mislabe<br>Misread<br>Off-set     | ion Incomplete/Unqualified<br>tions Incomplete/Unclear<br>gned/off center<br>eled<br>d |    | Outside Dimo<br>Over/Under<br>Part Incorred<br>Part Lost/Mi<br>Part Moved<br>Positioned W<br>Power Loss/S | tolerance<br>ct<br>ssing                      | Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other |  |
|  |  | g Sequence   |      |       | Finish Fit/Function   | -                          |  | Calibration  | _  |   |   |   |  |
|  | [wave/   | Twist in Tul | ne   | 1 1   | Fit/Function  |                            | Out of 9   | Sequence   |    |   |   |   |  |

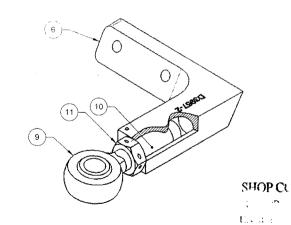
| ITEM | QTY<br>-041 | QTY<br>-042 | QTY<br>-043 | QTY<br>-044 | PART NUMBER | DESCRIPTION                   |
|------|-------------|-------------|-------------|-------------|-------------|-------------------------------|
| 1    | X           |             |             |             | D3957-041   | HINGE ASSEMBLY, DOOR LH UPPER |
| 2    |             | х           |             |             | D3957-042   | HINGE ASSEMBLY, DOOR RH UPPER |
| 3    |             |             | X           |             | D3957-043   | HINGE ASSEMBLY, DOOR LH LOWER |
| 4    |             |             |             | Х           | D3957-044   | HINGE ASSEMBLY, DOOR RH LOWER |
| 5    | 1           |             |             |             | D3957-1     | HINGE, DOOR LH UPPER          |
| 6    |             | 1           |             |             | D3957-2     | HINGE, DOOR RH UPPER          |
|      |             |             | 1           |             | D3957-3     | HINGE, DOOR LH LOWER          |
| 8    |             |             |             | 1           | D3957-4     | HINGE, DOOR RH LOWER          |
| 9    | 1           | 1           | 1           | 1           | D3518-3     | ROD END                       |
| 10   | 1           | 1           | 1           | 1           | MS124818    | HELICOIL, 3/8-24 UNF          |
| 11   | 1 1         | 1           | 1           | 1           | NAS509-6    | NUT                           |



## D3957-041 HINGE ASSY, DOOR LH UPPER



D3957-043 HINGE ASSY, DOOR LH LOWER



D3957-042 HINGE ASSY, DOOR RH UPPER SUBJECT TO ALMENDMENT

> WITHOUT NOTICE WORK ORDER NO. 402549 MCS

13-05-30

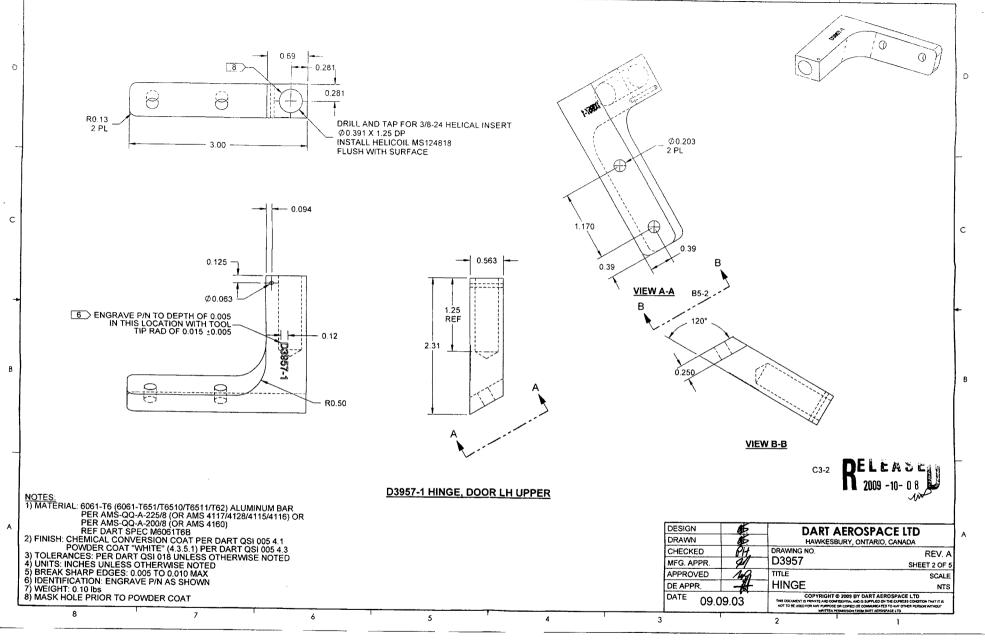
D3957-044 HINGE ASSY, DOOR RH LOWER



| Α           | NEW IS     | SUE          |   | 15 | 09.09.03             |  |  |  |  |  |
|-------------|------------|--------------|---|----|----------------------|--|--|--|--|--|
| REV.        |            |              | DESCRIPTION   | BY | DATE                 |  |  |  |  |  |
| DESIG       | N          | <b>\$</b> 5. | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA                                    |    |                      |  |  |  |  |  |
| DRAW        | N          | <b>3</b> 5-  |   |    |                      |  |  |  |  |  |
| CHECKED PH. |            | PH.          | DRAWING NO.   |    | REV. A               |  |  |  |  |  |
| MFG. A      | MFG. APPR. |              | D3957   |    | SHEET 1 OF 5         |  |  |  |  |  |
| APPRO       | OVED       | 149          | TITLE   |    | SCALE                |  |  |  |  |  |
| DE API      | PR.        | _#           | HINGE   |    |                      |  |  |  |  |  |
| DATE        | 09.0       | 9.03         | THIS DOCUMENT IS PRIVATE AND CONFIDENTLY<br>NOT TO BE USED FOR ANY PURPOSE OR COP |    | CONDITION THAT IT IS |  |  |  |  |  |

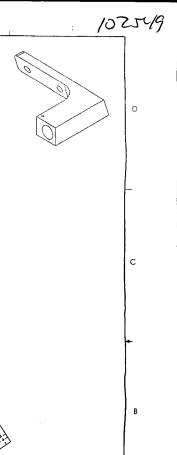
| DQA:               |                    | _ Date:     |        |  |                              |     |                        |                  |            |                |               | TAART                                 |
|--------------------|--------------------|-------------|--------|--|------------------------------|-----|------------------------|------------------|------------|----------------|---------------|---------------------------------------|
| QA Closed:         |                    | Date:       |        |  | WORK ORDER NON-              | -C( | ONFO                   | RMANCE / U       |            | Nork Ordon     | adata anki    | AEROSPACE                             |
| QA CIUSEU.         |                    | Date.       |        |  |                              |     |                        |                  |            | Vork Order u   | odate only    |                                       |
| Work Orde          | er:                |             |        |  | DISPOSITION                  |     |                        |                  | AGAINST D  | EPARTMENT      | /PROCESS      |                                       |
|                    | <del>- ,</del>     |             |        |  | Rework                       |     |                        | Skid-tube        | Crosstube  |                | Water Jet     | Engineering                           |
| Part N             | lo.                |             |        |  | Scrap                        |     |                        | Machining        | Small Fab  | Pro            | d. Eng. Coor. | Quality                               |
|                    |                    |             |        |  | Use-as-is                    |     | Thermoforming Finishir |                  |            | <del>_</del> i | re/Packaging  | Other                                 |
| NCR No.            |                    |             |        |  | Suspected Unapproved         |     |                        | Large Fab        | Composite  |                | Supplier      |                                       |
| Root De            |                    |             |        |  | ription of work order update |     | nitial                 | Λ -              | A:         | C: 0           | ·<br>         | <u> </u>                              |
| Cause              | Date               |             |        |  | or non-conformance           | !   |                        |                  | tion       | Sign &         | Varification  | OC Inchestor                          |
| Т                  | Date               | Step        | Qty    |  | or non-comormance            | Cn  | iief <sub>,</sub> Eng  | Desc             | ription    | Date           | Verification  | QC Inspector                          |
| Design<br>Doc/Data | -                  |             |        |  |                              |     |                        |                  |            |                |               |                                       |
| Equip/Tooling      | _                  |             |        |  |                              |     |                        |                  |            |                |               |                                       |
| Handling/Pre       | -                  |             |        |  |                              |     |                        |                  |            |                |               |                                       |
| Material           | -                  |             |        |  |                              |     |                        |                  |            |                |               |                                       |
| Operator           |                    |             |        |  |                              |     |                        |                  |            |                |               | ,                                     |
| Offset/Setup       |                    |             |        |  |                              |     |                        |                  |            |                |               |                                       |
| Process            |                    |             |        |  |                              |     |                        |                  |            |                |               |                                       |
| Supplier           |                    | 1           |        |  |                              |     |                        |                  |            |                |               |                                       |
| raining            |                    |             |        |  |                              |     |                        |                  |            |                |               |                                       |
| Fransport          |                    |             |        |  |                              |     |                        |                  |            |                |               |                                       |
| Jnapproved         |                    |             |        |  |                              |     |                        |                  |            |                |               |                                       |
|                    |                    |             |        |  |                              | FAI | ULT CAT                | TEGORY           |            |                |               | · · · · · · · · · · · · · · · · · · · |
| Landir             | ng Gear            |             |        |  | General                      |     |                        |                  |            |                |               |                                       |
|                    | Bending            |             |        |  | Bend                         |     | Folio/F                | rogram           | Γ          | Outside Dim    | ensions       | Pressure/Forced                       |
|                    | Centre N           | lot Conce   | ntric  |  | BOM/Route                    |     | Grain                  |                  |            | Over/Under     | tolerance     | Set-up                                |
| ļ                  | Cracks             |             |        |  | Broken/Damage/Defect         |     | Hardwa                 | re               |            | Part Incorre   | ct            | Temperature/Cure                      |
|                    | Crimp/K            | ink/Ripple  | e/Wave |  | Burrs                        |     | Inspect                | ion Incomplete/U | nqualified | Part Lost/M    | issing        | Weld                                  |
| Ļ                  | Cuffs              |             |        |  | Contamination                |     | Instruct               | ions Incomplete/ | Unclear    | Part Moved     |               | Wrong Stock Pulled                    |
|                    | Crushing           | g           |        |  | Countersink                  |     | Misalig                | ned/off center   |            | Positioned V   | Vrong         |                                       |
| <u> </u>           | Heat Tre           | at          |        |  | Cut Too Short                |     | Mislabe                | eled             |            | Power Loss/    | Surge         | Other                                 |
| ]                  |                    | on Strip in | Tube   |  | Drawing                      | _   | Misread                | 1                |            |                | -             |                                       |
| ļ                  | Marks/C            |             |        |  | Drill Holes                  |     | Off-set                |                  |            |                |               | -                                     |
| ļ                  |                    | Sequence    |        |  | Finish                       |     | Out of (               | Calibration      |            |                |               |                                       |
|                    | Wave/Twist in Tube |             |        |  | Fit/Function                 |     | Out of                 | Sequence         |            |                |               | -                                     |





| DQA:         |                    | Date:     |       |             |   |          |         |  |  |                |                                       |   | <b>™</b> ⊃∧DT             |
|--------------|--------------------|-----------|-------|-------------|---|----------|---------|--|--|----------------|---------------------------------------|---|---------------------------|
| QA Closed:   |                    | Date:     |       |             | WORK ORDER NON-                             | -CO      | NFO     | RMANCE / L                                 | JPDATE   | W              | ork Order up                          | odate only                                    | AEROSPACE                 |
| Work Orde    | er:                |           |       |             | DISPOSITION                                 |          |         |  | AGAINST  | DE             | PARTMENT                              | /PROCESS                                      |                           |
| Part N       |                    |           |       | _           | Rework Scrap Use-as-is Suspected Unapproved |          | Therm   | Skid-tube  Machining  noforming  Large Fab | Crosstube<br>Small Fab<br>Finishing<br>Composite |                | 1                                     | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other |
| Root         | Root Des           |           |       | Desci       | ription of work order update                | in       | nitial  | Δα   | ction  |                | Sign &                                |   |                           |
| Cause        | Date               |           |       |             | or non-conformance                          | 1        | ef Eng  | l  | cription   |                | Date                                  | Verification                                  | QC Inspector              |
| Design       |                    |           |       |             |   |          |         |  |  |                |                                       | v cittled tion                                | Qu'inspecto.              |
| Doc/Data     |                    |           |       |             |   |          |         |  |  |                |                                       |   |                           |
| quip/Tooling |                    |           |       |             |   |          |         |  |  |                |                                       |   |                           |
| landling/Pre |                    |           |       |             |   |          |         |  |  |                |                                       |   |                           |
| Material     |                    |           |       |             |   |          |         |  |  |                |                                       |   |                           |
| Operator     |                    |           |       | •           |   |          |         |  |  |                |                                       |   |                           |
| Offset/Setup |                    |           |       | t           |   |          |         |  |  |                |                                       |   |                           |
| Process      |                    |           |       |             |   |          |         |  |  |                |                                       |   |                           |
| upplier      |                    | i         |       |             |   |          |         |  |  |                |                                       |   |                           |
| raining      |                    |           |       |             |   |          |         |  |  |                |                                       |   |                           |
| ransport     |                    |           |       |             |   |          |         |  |  |                |                                       |   |                           |
| Jnapproved   |                    |           |       |             |   |          |         |  |  |                |                                       |   |                           |
|              |                    |           |       |             |   | FAU      | LT CAT  | EGORY                                      |  |                |                                       |   |                           |
| Landir       | ng Gear            |           |       | -           | General                                     |          |         |  |  |                | · · · · · · · · · · · · · · · · · · · |   |                           |
| [            | Bending            |           |       |             | Bend  |          | Folio/P | rogram                                     |  |                | Outside Dim                           | ensions [                                     | Pressure/Forced           |
|              | Centre No          | ot Concer | ntric |             | BOM/Route                                   | $\vdash$ | Grain   | Ü  |  |                | Over/Under                            | <b>⊢</b>                                      | Set-up                    |
|              | Cracks             |           |       |             | Broken/Damage/Defect                        | —        | Hardwa  | re   |  |                | Part Incorred                         | <b> </b>                                      | Temperature/Cure          |
| [            | Crimp/Kir          | nk/Ripple | /Wave |             | Burrs                                       | $\vdash$ |         | on Incomplete/U                            | Inqualified .                                    |                | Part Lost/Mi                          | <b>⊢</b>                                      | Weld                      |
|              | Cuffs              |           |       |             | Contamination                               |          | •       | ions Incomplete/                           | , ,,   |                | Part Moved                            | - F   | Wrong Stock Pulled        |
| . [          | Crushing           |           |       | _           | Countersink                                 |          |         | ned/off center                             |  |                | Positioned W                          |   |                           |
|              | Heat Treat         |           |       |             | Cut Too Short                               | $\vdash$ | Mislabe |  | •  | $\vdash$       | Power Loss/S                          |   | Other                     |
|              |                    |           |       | Drawing     | $\vdash$                                    | Misread  |         |  | ш  | 1 2 2 . 2000/1 |                                       | To the last                                   |                           |
| Ţ            |                    |           |       | Drill Holes | $\vdash$                                    | Off-set  |         |  |  |                |                                       |   |                           |
| Ī            | Turning S          | equence   |       |             | Finish                                      | $\vdash$ |         | Calibration                                |  |                |                                       |   |                           |
|              | Wave/Twist in Tube |           |       |             | Fit/Function                                | -        |         | equence                                    |  |                |                                       |   |                           |

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH



VIEW H-H C3-5

Ø0.203 2 PL

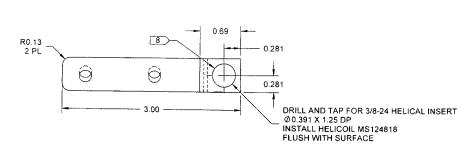
VIEW G-G B5-5

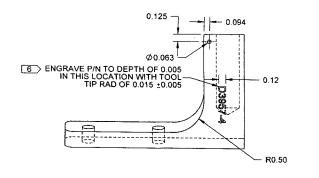
1.170

0.39

RELEASE U

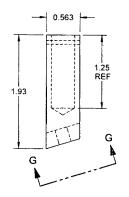
| DESIGN     | 5          | DART AFRO  | OSPACE LTD   |  |  |  |  |  |
|------------|------------|--|--------------|--|--|--|--|--|
| DRAWN      | <b>3</b> 5 | HAWKESBURY, ONTARIO, CANADA  |              |  |  |  |  |  |
| CHECKED    | PH.        | DRAWING NO.  | REV. A       |  |  |  |  |  |
| MFG. APPR. | 94         | D3957  | SHEET 5 OF 5 |  |  |  |  |  |
| APPROVED   | 149        | TITLE  | SCALE        |  |  |  |  |  |
| DE APPR.   |            | HINGE  | . NTS        |  |  |  |  |  |
| DATE 09.0  | 9.03       | COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMANDANT TO OWN OTHER PERSON WITHOUT WHATTHER PRESSENCE FOR DIGHT LENDONGE IT |              |  |  |  |  |  |





D

С



## D3957-4 HINGE, DOOR RH LOWER

| NOTES: 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) REF DART SPEC M6061T6B 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED | 13 | 0 |
|--|----|---|
| 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN 7) WEIGHT: 0.09 lbs 8) MASK HOLE PRIOR TO POWDER COAT   | _  | 0 |

5

| RT                      |
|-------------------------|
| SPACE                   |
|                         |
| ng<br>ty<br>er          |
|                         |
| ector                   |
| 20101                   |
|                         |
|                         |
| ced<br>e/Cure<br>Pulled |
|                         |
|                         |